

Work Order ID 74120

Thursday, September 22, 2011 2:31:17 PM



Page 1

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 9/22/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 7.00



Customer:

Reference:

Approvals: Process Plan: *WV*

Date: 11-09-22 Tooling: Date:

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3264 | Rev A2 |

100



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 5.700" LONG

0.00

*onk 11/09/26**7 0*

110



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOILIO FA447

FOLIO REV: *AA*DWG REV: *A*

0.00

*SK 11-09-26**7 e*

DEBURR AS PER DWG

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 74120

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Page 2

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Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 9/22/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 7.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

SL 11-09-26

7 10

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

and 11/09/27

7 10

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

7 6 11/09/27

Hand Finishing

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Thursday, September 22, 2011 2:31:15 PM

Page 1

Work Order ID: 74120



Parent Item: D3264-1



Parent Item Name: Bracket

Start Date: 9/22/2011

Required Date: 9/28/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP A 04.09.02 New issue KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B1.250X04.50 0 | | Purchased | | No | | | f | 4.2417 | | 3.5 | | | |

6061-T6 Bar 1.25 X 4.50



| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT004 | 4.2417 | |
| 112628 | 4.2417 | |

3.5 anh 1/09/26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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| DART AEROSPACE LTD | | Work Order: | 74120 |
| Description: Bracket | | Part Number: | D3264-1 |
| Inspection Dwg: D3264 | Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.687 | +/-0.010 | .687 | / | | MPK | SL-3 |
| 0.063 | +/-0.010 | .061 | / | | | |
| 0.125 | +/-0.010 | .124 | / | | | |
| 0.875 | +0.010/-0.020 | .875 | / | | | |
| 0.062 | +/-0.010 | .063 | / | | RG | |
| R0.03 | +/-0.030 | .03 | / | | RG | |
| R0.13 | +/-0.030 | .125 | / | | | |
| 1.00 | +/-0.030 | 1.00 | / | | | |
| 0.125 | +/-0.010 | .126 | / | | | |
| 0.600 | +/-0.010 | .600 | / | | | |
| 4.000 | +/-0.005 | 4.000 | / | | | |
| 0.750 | +/-0.010 | .750 | / | | | |
| Ø0.194 | +0.005/-0.000 | .194 | / | | | |
| 5.50 | +/-0.030 | 5.500 | / | | | |
| 0.125 | +/-0.010 | .126 | / | | | |
| 0.063 | +/-0.010 | .065 | / | | | |
| R0.25 | +/-0.030 | .25 | / | | RG | |
| 4.27 | +/-0.030 | 4.271 | / | | | |
| R0.30 | +/-0.030 | .300 | / | | | |

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | SL | Audited by: | Onf | Prototype Approval: | N/A |
| Date: | 11-09-26 | Date: | 11/09/27 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------------|------------|----------|
| A | 04.09.03 | New Issue | KJ/JLM | |
| B | 05.04.26 | Ø0.194 was Ø0.208; dimensions removed | KJ/JLM | |
| C | 07.10.10 | Tolerance for 0.875 revised | KJ/EC/DD | JK |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

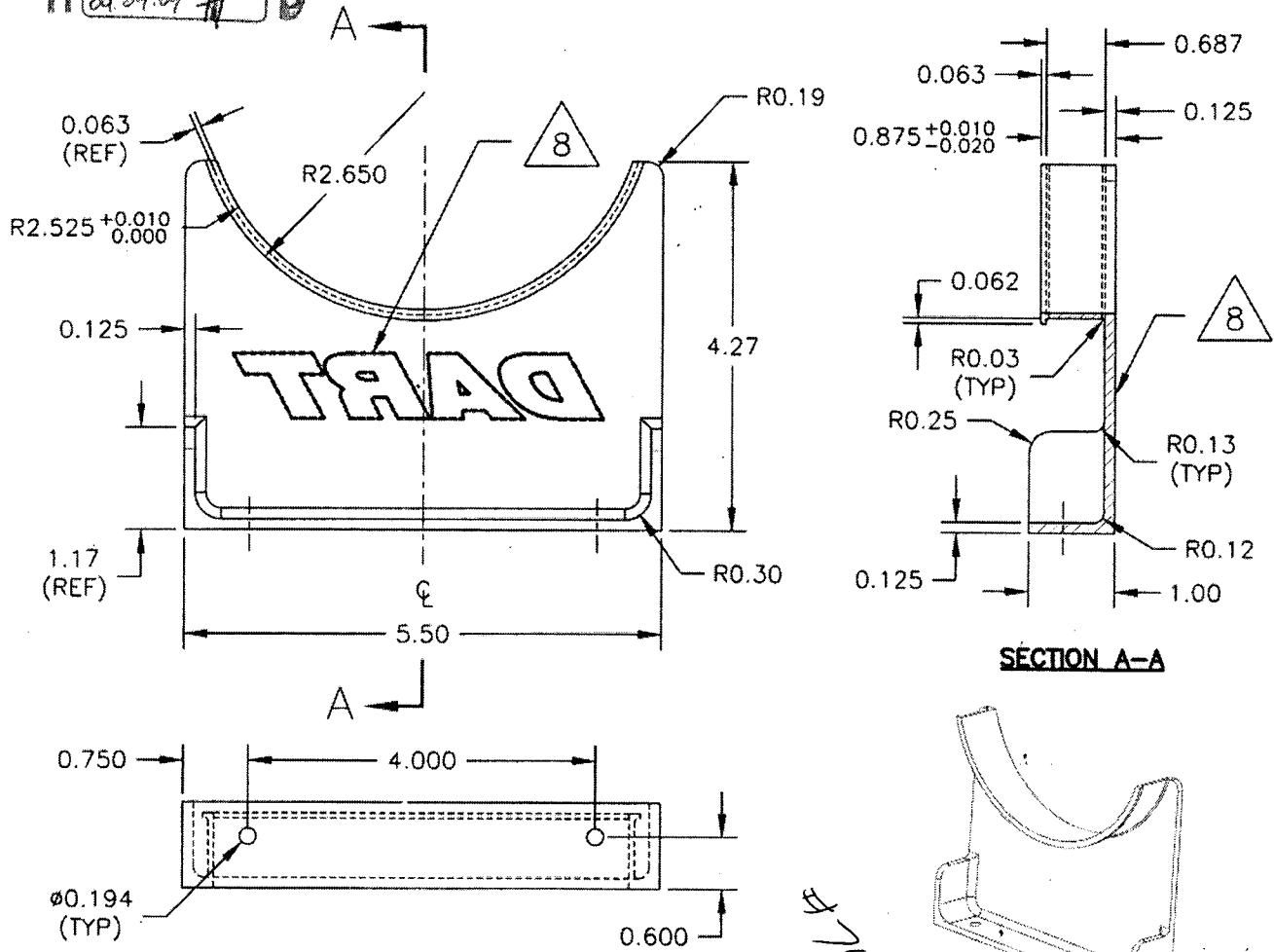
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DARTCOPY ISSUED
DATE

| | | |
|----------------------|-----------------------|---|
| DESIGN <i>RF</i> | DRAWN BY <i>RF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>RF</i> | APPROVED <i>RF</i> | DRAWING NO. D3264 |
| DATE 04.04.20 | | REV. A |
| | | SHEET 1 OF 1 |
| | | SCALE 1:2 |
| A | 04.04.20 | NEW ISSUE |

RELEASED
04.09.09 *RF***D3264-1 BRACKET****D3264-1:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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